

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018750**Date Inspected:** 09-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	An Qing Xing		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A
Component:	OBG COMPONENT	

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Trial Assembly Yard

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG segment 11AE to 11BE, weld No.DP705-001-007. The welder is identified as #040320. ZPMC QC is identified as Mr.An Qing Xing .The welding variables recorded by QC appear to comply with WPS-B-T-4114-1.

SMAW in the 4F position for the OBG segment 11AE to 11BE, weld No.DP717-001-013. The welder is identified as #044504. ZPMC QC is identified as Mr.An Qing Xing .The welding variables recorded by QC appear to comply with WPS-B-T-4114-1.

Bay#19

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Suspender Bracket SB86E, UT repair weld No.SB20-086-037. The welder is identified as #062762. ABF QA is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-REPAIR. The weld repair report is identified as WR15676.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay#16

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG longitudinal Diaphragm lifting Lug, weld No.LD3034-001-194. The welder is identified as #040344. ABF QA is identified as Mr.Li Shi You .The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U5-F.

FCAW in the 2F position for the OBG Segment 13AW bottom plate to stiffener, weld No.BP3056-001-089/090. The welders are identified as #070254 and #037705. ZPMC QC is identified as Mr.Liu Dao Fang .The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U5-F.

Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between side Plate to side Plate for segment 10BE to 10CE at Cross Beam side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

OBE10C-001,002

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
